

# Work Order ID 50109

July 08, 2009 11:24:49 AM

Page 1

Item ID: D350-588-011 Accept Setup Start  
 Revision ID: N/A Stop  
 Item Name: Aft Door Fwd Hinge Modification  
 Start Date: 7/10/2009 Start Qty: 4.00 Cust Item ID:  
 Required Date: 7/31/2009 Req'd Qty: 4.00 Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev N/A								

100 DOCUMENT CONTROL 0.00  
 DC Memo 09/07/13 0.00  
 Document Control Photocopy bluefile and create labels per PPP D350-588-011 CHG002

S 07/07/22

110 Pick Kit 0.00  
 Packaging Memo 0.00  
 Packaging

9/7/22 44 SP

120 QC4- 100% Inspect kits for completeness 0.00  
 QC Memo 0.00  
 Quality Control

=> S 07/07/22

24 f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 50109

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Item ID: D350-588-011

Accept

Setup Start

Revision ID: N/A

Stop

Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/10/2009 Start Qty: 4.00

Cust Item ID:

Required Date: 7/31/2009 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-588-011 <input type="checkbox"/> Location: _____ <input type="checkbox"/> PPP Rev: <u>C</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

9/7/22 (40) Sy

09/07/23 JF

mf 09-07-23

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 50109

Parent Item: D350-588-011RevN/A

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN526C1032R7	x2	Purchased	No			120	Each	74.0000	8.0000			
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Screw

Warehouse  
Location

Loc QtyLoc Code

Main Warehouse

ST

74

104394

4

110715

70

AN526C832R8	x8	Purchased	No			120	Each	164.0000	32.0000			
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Screw

Warehouse  
Location

Loc QtyLoc Code

Main Warehouse

ST

164

108335

1

111900

163

1110715 8 8/29/10

111900 32 8/29/10

W/O:		WORK ORDER CHANGES					
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Required Date: 7/31/2009

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Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C832R9	XB	Purchased	No			120	Each	346.0000	32.0000			

Screw

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

346

107376

51

108377

5

108928

14

110372

8

110915

1

111916

267

120

Each

1,213.000 16.0000

11/19/6 32x 10

AN960JD10

Purchased

No

Washer

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

1213

105442

95

109059

2

109840

23

110985

202

111279

13

111668

878

11/16/08 16x 12 9/1/15

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Required Date: 7/31/2009

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD8 <i>x24</i>		Purchased	No			120	Each	975.0000	<i>96.0000 24</i>			
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*S*  
*Washer*

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

975

107091

9

108335

11

110382

48

110917

3

111578

904

*S*  
D2143RevC1 *2*

Manufactured No

120

Each

37.0000

4.0000

*H*  
Hinge Bracket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

37

37739

37

*S*  
D2144RevD *2*

Manufactured No

120

Each

22.0000

4.0000

*H*  
Hinge Bracket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

22

41174

22

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Start Date: 7/10/2009

Required Date: 7/31/2009

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Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2150RevA	x2	Manufactured	No			120	Each	32.0000	8.0000			

Packer Doubler, Hinge

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

32

45813

32

D2151RevB x2

Manufactured No

120

Each

13.0000

8.0000

45813 8 x C

Packer Doubler, Hinge

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

13

44889

13

D2153RevA1 x1

Manufactured No

120

Each

52.0000

4.0000

44889 8 x C

D2153-3315-10

Door Prop 6700 Spring 12007.

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

52

21572

0

45058

16

48373

36

45058 4 x 12/15

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Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2154RevC	X1	Manufactured	No			120	Each	37.0000	4.0000			

Stud Bracket

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	37	
44890	19	
45814	18	

D2237RevD1 X2

Manufactured No

120 Each 30.0000 8.0000

Striker Plate

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	30	
46162	30	

D2461RevA 871

Manufactured No

120 f 231.2300 30.5263

D2461-0830 X1

Neoprene "D" Seal

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	231.23	
29048	7.79	
34304	22.38	
39782	201.06	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 50109

Parent Item: D350-588-011RevN/A

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2463RevA		Manufactured	No			120	f	75.3763	29.0000			
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D2463-0870

Seal

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

75.3774

25153

0

31350

1.83

34305

18.25

41121

3.75

43841

51.5474

D2583RevB

Manufactured No

120

Each

35.0000

8.0000

Latch Bracket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

35

36043

2

48648

33

B50075

9/1/21 SD

48648

12/1/14

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 50109

Parent Item: D350-588-011RevN/A

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2585RevB	X2	Manufactured	No			120	Each	22.0000	8.0000			
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Mounting Channel

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

22

45888

22

D2586RevD	X2	Manufactured	No			120	Each	74.0000	8.0000			
-----------	----	--------------	----	--	--	-----	------	---------	--------	--	--	--

Door Latch

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

74

23082

0

45554

1

47183

73

D2587RevA1	X1	Manufactured	No			120	Each	61.0000	4.0000			
------------	----	--------------	----	--	--	-----	------	---------	--------	--	--	--

Door Slug, 350 Hinge

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

61

48647

61

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 50109

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Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/10/2009

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2589RevA		Manufactured	No			120	Each	36.0000	4.0000			
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Keys, Key Chain, 350 Hinge

Warehouse Location	Loc Qty	Loc Code
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Main Warehouse

ST	36	
----	----	--

46840	36	
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D2690-17RevB2		Manufactured	No			120	Each	6.0000	4.0000			
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Cable

Warehouse Location	Loc Qty	Loc Code
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Main Warehouse

ST	6	
----	---	--

48234	6	
-------	---	--

D2857-1RevB		Manufactured	No			120	Each	30.0000	4.0000			
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Hinge Bracket

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST	30	
----	----	--

41166	7	
-------	---	--

45788	23	
-------	----	--

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D2857-2RevB	x1	Manufactured	No			120	Each	38.0000	4.0000			

Hinge Bracket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	38	
43363	12	
45797	26	

By 3363 4x *cu*

D2858-1RevB x1

Manufactured No

120

Each

41.0000

4.0000

Hinge Bracket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	41	
43364	11	
45798	30	

43364 4x *cu*

D2858-2RevB x1

Manufactured No

120

Each

33.0000

4.0000

Hinge Bracket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	33	
41439	12	
45799	21	

41439 4x *cu 7/7/09*

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FG-778150-550-ROL	*1	Purchased	No			120	sf	1,088.000	4.0000			

150 FT  
7781 9oz Glass 50"x125yd

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

1088

111166

1088

MS20426AD3-4 \*12

Purchased

No

\* 1108532

120

Each

8,433.000

48.0000 12

1108532 YX

9/7/14

RIVET

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

8433

104374

4433

110398

4000

MS20470AD4-5 \*18

Purchased

No

120

Each

4,216.000

72.0000 18

1104374 YX / 9/7/14

Rivet, Universal Head

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

4216

109031

1216

111916

3000

1109031 72X 9/7/14 (4)

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 50109

Parent Item: D350-588-011RevN/A

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042L08	NIS	Purchased	No			120	Each	222.0000	72.0000			
------------	-----	-----------	----	--	--	-----	------	----------	---------	--	--	--

Warehouse	Loc Qty	Loc Code
Location		

Main Warehouse		
ST	222	
110002	24	
111889	198	

MS21042L3	XY	Purchased	No			120	Each	1,834.000	16.0000			
-----------	----	-----------	----	--	--	-----	------	-----------	---------	--	--	--

Warehouse	Loc Qty	Loc Code
Location		

Main Warehouse		
ST	1834	
110844	34	
111274	800	
111668	1000	

M111889 70X 8/9/14  
M112243 2X 9/1/12 54

M11274 16X 8/9/14 (4)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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July 08, 2009 11:24:49 AM

Work Order ID: 50109

Parent Item: D350-588-011RevN/A

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/10/2009

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS27039-08-11	XZ	Purchased	No			120	Each	139.0000	8.0000			
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Screw

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

139

104427

6

108335

33

111977

100

MS27039-1-15	XZ	Purchased	No			120	Each	116.0000	8.0000			
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Screw

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

116

106903

3

108169

4

109321

4

110915

5

111916

100

11108335 8X / 6/9/14

1110915 5X  
1111916 3X / 6/9/13 (4)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

\* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

## 52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	½" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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